

Work Order ID 154203

Tuesday, December 06, 2016 2:50:33 PM

154203

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Item ID: D2365 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Pip Pin
 Start Date: 11/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/6/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **DEC 06 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2365	Rev C							DAS 46 9-89	16/12/11

100 0.04
100 FLOW WATER JET
 Waterjet Memo 0.01
 FLOW CNC Waterjet 1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.01
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.02
 Quality Control

Ce

Ce **DAS 46 9-89** 16/12/11

Ce **DAS 38 9-89** DEC 12 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	0.02				(X6)			2016/12/14 BEB
140	QC7-Inspect Chemical Conversion Coat	0.00							
140 QC Quality Control	Memo	0.01				6X			16/12/15 DAS 36 9-89
150	Small Fab	0.00							
150 Small Fab Small Fab	Memo Install Insert as per Dwg D2365	0.01				6X			16/12/15 DAS 36 9-89

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[illegible]

Picklist Print

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Page 1

Work Order ID: 154203

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Parent Item: D2365

D2365

Parent Item Name: Wearplate Pip Pin

Start Date: 11/28/2016

Required Date: 12/6/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
(IPP Rev:B Now On Waterjet 08-04-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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FE-832-EF		Purchased		No		100	Each	25.0000	2	12			
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FF-832-FF

PEM Insert

DAS
36
9-89
16/12/15

Location

Loc Qty

Loc Code

GA

25

m136047

25

M6061T6S.063

Purchased

No

150

sf

334.2300

0.0047

0.029684

M6061T6S 063

6061-T6 .063 Sheet

DAS
46
9-89
16/12/11

Location

Loc Qty

Loc Code

MAT021

334.23

M133511

2.6

M134377

3.3

M134830

160.43

M136251

167.9

0.05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

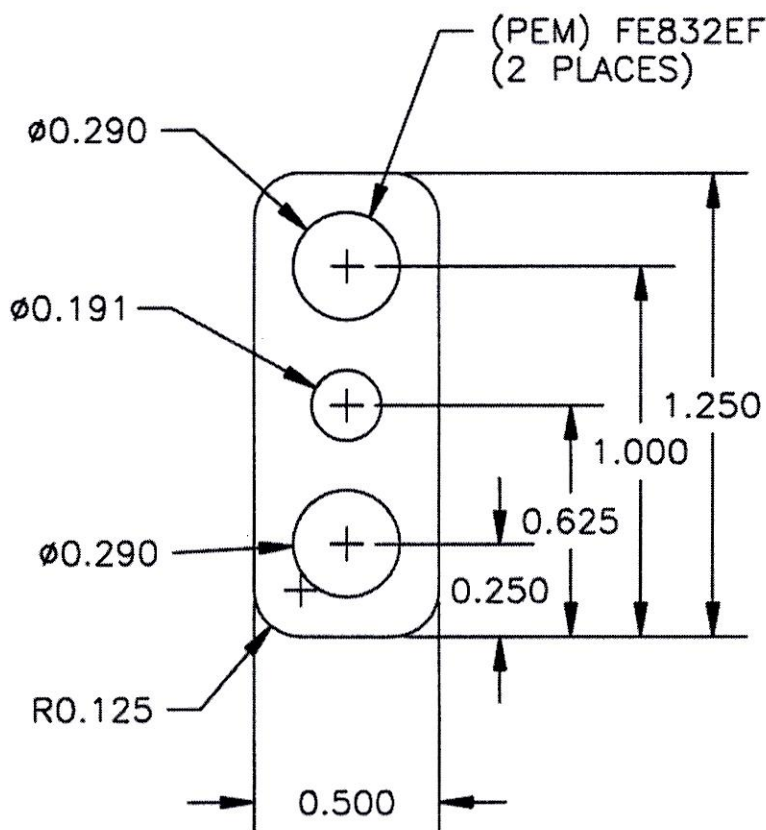
QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER : _____			

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED B W	APPROVED [Signature]	D2365	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		2:1
C	95:03:06	0.191 WAS 0.197	

RELEASED
17/04/22 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154205 ucs
16-12-06

6061-T6 (Q2-A-250/11) 0.063 THICK } # 00.09.26
ACID ETCH & ALDINE PER QSI D05 4.1.1 } #
INSMUL FE832EF (2 PLS) AFTER ALDINE }
~~ALSI 304/316 SS~~
MATERIAL: ~~6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK~~
~~AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES~~ } # 00.03.07

DQA: _____ Date: _____



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Work Order update only ☐

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OTHER : ☐					